



Dart Aerospace Ltd.  
1270 Aberdeen St  
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K6A 1K7  
Canada

Tel (613) 632-5200

**D5106-1**

**Job Sheet 177192**



**Part No:** D5106-1

**Job Qty:** 12 ea

**Part Name:** Bracket



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 5/8/18

**Job Tracking No:**

**Due Date:** 6/15/18

**Created By:** Michelle Gagnon-Donovan

**Type:** Stock

**Description:**

**Note:** DWG REV A IPP REV A RQ VERIFIED BY DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                |
|-------|------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------------------|
|       |                        |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                         |
| 90    | Start up Operation     | 12 Ea  | 6/15/18    | 6/15/18  | 0.00      | 0.00    | Start Up Machining-3  |           | DAS                     |
| 100   | Bandsaw                | 12 pcs | 6/15/18    | 6/15/18  | 0.00      | 1.74    | Bandsaw1              |           | 54                      |
| 110   | CNC Vertical Machining | 12 pcs | 6/15/18    | 6/15/18  | 0.09      | 16.22   | HAAS1-4               |           | 9-89                    |
| 120   | QC                     | 12 pcs | 6/15/18    | 6/15/18  | 0.00      | 0.00    | QC8 Machining-3       |           | 7/18/07/04              |
| 122   | Mill Conv              | 12 pcs | 6/15/18    | 6/15/18  | 0.00      | 2.38    | Mill Conv 1           |           | FM 18/07/04             |
| 130   | QC                     | 12 pcs | 6/15/18    | 6/15/18  | 0.00      | 0.00    | QC8                   |           | 7/18/07/04              |
| 140   | Packaging              | 12 pcs | 6/15/18    | 6/15/18  | 0.00      | 0.00    | Packaging3-2          | 5/14/18   | JUL 05 2018             |
| 150   | QC21-SA                | 12 Ea  | 6/15/18    | 6/15/18  | 0.00      | 0.00    | QC21                  |           | DAS 21 9-89 JUL 05 2018 |

Part Op 100 - Cut blank to 2.63" long  
Descriptions: 110 - 1-MILL as per folio FB332&dwg.  
122 - Drill hole for lanyard as per dwg.

### Job BOM

| Part / Item      | Component Name      | Quantity            | Operation             | Container |
|------------------|---------------------|---------------------|-----------------------|-----------|
| M303B2.000X1.750 | 303 Bar 2" X 1.750" | 2.6280 ft (.219 ea) | 90-Start up Operation | M136304   |

### Job Allocations

| Operation             | Component Part   | Required | Inventory | Allocated |
|-----------------------|------------------|----------|-----------|-----------|
| 90-Start up Operation | M303B2.000X1.750 | 3        | 3         | 0         |

**DART**  
AEROSPACE

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Container No: S085363



Part: D5106-1

Job No: 177192

Serial No/Batch: S085363

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/28/18

8-80  
52  
8-80

8-80  
52  
8-80

| Part Specifications |             |                                    |                  |          |                  |
|---------------------|-------------|------------------------------------|------------------|----------|------------------|
| Spec No             | Description | Target/Tolerance                   | Limits           | Type     | Special Comments |
| 1                   | Upper Rail  | 0.780Inches $\pm$ 0.010            | 0.790<br>0.770   |          |                  |
| 2                   | Upper Rail  | 0.490Inches $\pm$ 0.030            | 0.520<br>0.460   |          |                  |
| 3                   | Upper Rail  | 0.250Inches $\pm$ 0.030            | 0.280<br>0.220   |          |                  |
| 4                   | Upper Rail  | 45.000Degrees $\pm$ 0.500          | 45.500<br>44.500 | Angle    |                  |
| 5                   | Upper Rail  | 0.780Inches $\pm$ 0.010            | 0.790<br>0.770   |          |                  |
| 6                   | Upper Rail  | 0.575Inches $\pm$ 0.010            | 0.585<br>0.565   |          |                  |
| 7                   | Upper Rail  | 1.150Inches $\pm$ 0.010            | 1.160<br>1.140   |          |                  |
| 8                   | Upper Rail  | 0.300Inches $\pm$ 0.010            | 0.310<br>0.290   |          |                  |
| 9                   | Upper Rail  | 2.180Inches $\pm$ 0.030            | 2.210<br>2.150   |          |                  |
| 10                  | Upper Rail  | 0.257Inches $\pm$ 0.006<br>- 0.001 | 0.263<br>0.256   | Diameter |                  |
| 11                  | Upper Rail  | 0.750Inches $\pm$ 0.030            | 0.780<br>0.720   |          |                  |
| 12                  | Upper Rail  | 0.070Inches $\pm$ 0.030            | 0.100<br>0.040   |          |                  |
| 13                  | Upper Rail  | 30.000Degrees $\pm$ 0.500          | 30.500<br>29.500 | Angle    |                  |
| 14                  | Upper Rail  | 0.380Inches $\pm$ 0.030            | 0.410<br>0.350   |          |                  |
| 15                  | Upper Rail  | 0.200Inches $\pm$ 0.010            | 0.210<br>0.190   |          |                  |
| 16                  | Upper Rail  | 0.375Inches $\pm$ 0.010            | 0.385<br>0.365   |          |                  |
| 17                  | Upper Rail  | 1.230Inches $\pm$ 0.030            | 1.260<br>1.200   |          |                  |
| 18                  | Upper Rail  | 0.230Inches $\pm$ 0.030            | 0.260<br>0.200   |          |                  |
| 19                  | Upper Rail  | 1.500Inches $\pm$ 0.030            | 1.530<br>1.470   |          |                  |
| 20                  | Upper Rail  | 1.750Inches $\pm$ 0.030            | 1.780<br>1.720   |          |                  |
| 21                  | Upper Rail  | 0.750Inches $\pm$ 0.030            | 0.780<br>0.720   |          |                  |
| 22                  | Upper Rail  | 0.257Inches $\pm$ 0.006<br>- 0.001 | 0.263<br>0.256   | Diameter |                  |
| 23                  | Upper Rail  | 0.625Inches $\pm$ 0.008<br>- 0.001 | 0.633<br>0.624   | Diameter |                  |
| 24                  | Upper Rail  | 0.200Inches $\pm$ 0.100            | 0.300<br>0.100   |          |                  |
| 25                  | Upper Rail  | 0.700Inches $\pm$ 0.100            | 0.800<br>0.600   |          |                  |
| 26                  | Upper Rail  | 0.129Inches $\pm$ 0.005<br>- 0.001 | 0.134<br>0.128   | Diameter |                  |

Plex 5/8/18 10:29 AM Dart.Gagnon.Michelle

